

5/20
DART AEROSPACE LTD

Work Order:

23234

Description: Support Arm

Part Number:

D3165-1

Dwg: D3165 Rev. A

Qty:

30 32

Page 1 of 1






Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveller batch: M17029 (M6061T6 80.500 x 6.00)	[Signature]	05.05.09	30
2	MV	Cut Blank: (17.00" x 5.00") +/- 0.030" x 0.500" thick Material: 6061-T6/T651 (QQ-A-200/8 or QQ-A-250/11 or QQ-A-225/8) per (M6061T6B0.500x17.000) Grain along 17.000" 5.00" Batch M17037	[Signature]	05.05.09	22
			[Signature]	05.05.09	8
3	MV	Machine as per Folio FA277 & Dwg D3165-1	[Signature]	05/05/11	32
4	QC2	Inspect parts as they come off the CNC machine	[Signature]	05/05/11	32
5	MV	Deburr & Tumble	[Signature]	05/05/11	32
6A	QC8	Second check inspection	[Signature]	05/05/11	32
6B	MV	Engrave Batch number as per Dwg D3165	[Signature]	05/05/11	32
7	FP	Acid etch and alodine per QSI 005 4.1	[Signature]	05/5/11	32
8	FP	Powder Coat White (4.3.5.1) per QSI 005 4.3	[Signature]	05 05 12	32
9	QC3	Inspect Powder Coat	[Signature]	05/05/16	32
10	ST	Identify and Stock	[Signature]	05/05/16	32
11	AC	Cost / part 31.43	[Signature]	05-05-17	32
12	DC	Close W/O 31.43 Inspect Level 21	[Signature]	05.05.25	32

30
+1
PTO
2 extra
Parts

Rev	Date	Change	Revised By	Approved
A	02.09.18	New issue	KJ [Signature]	[Signature]

RELEASED
02/10/02 RF

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-05-09	3	1 part damaged by c-drill, wrong  , operator error	 12/05/09	Destroy + Replace	TBC. 05/05/10	 05-05-10	 12/05/09	 05-05-10

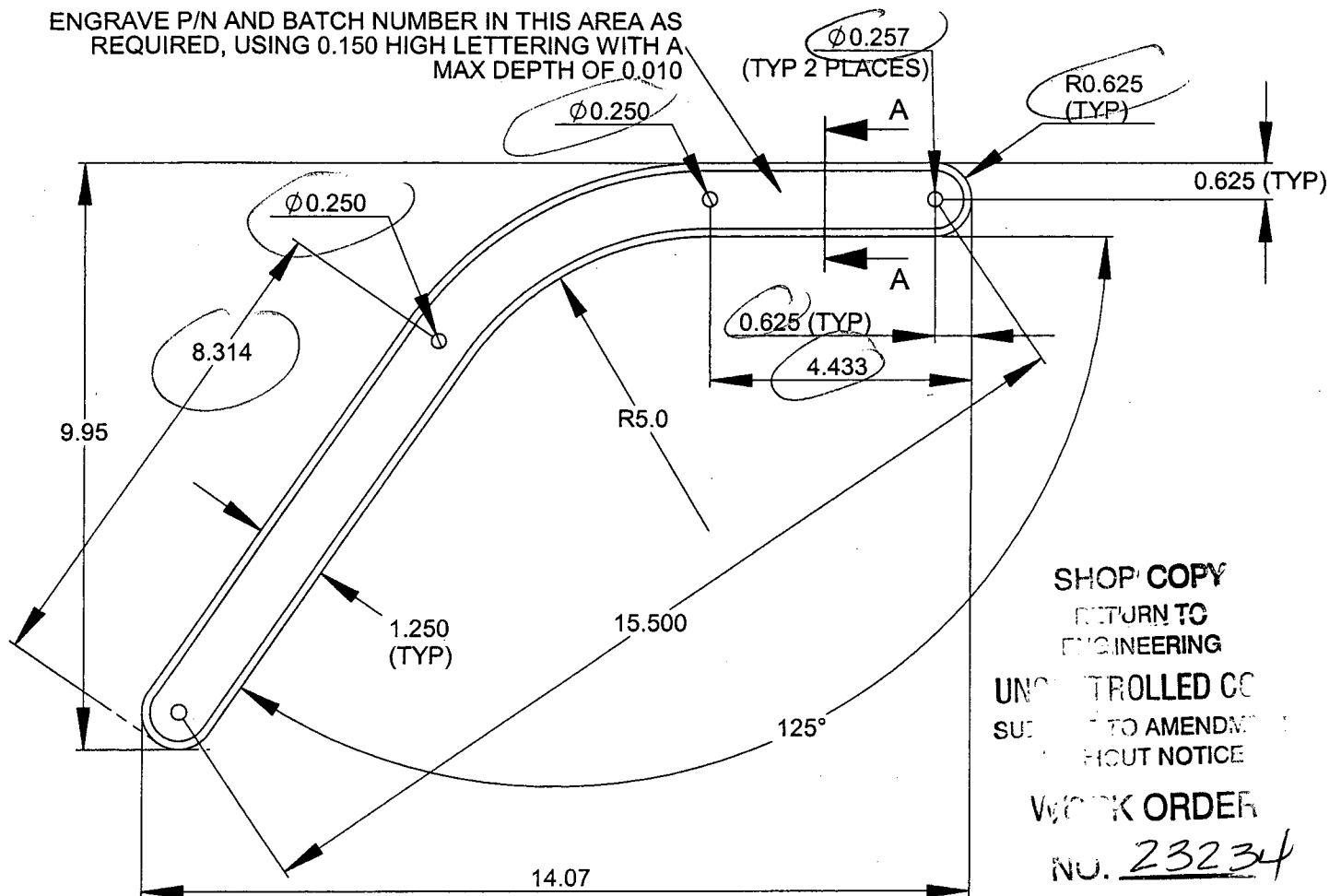
Part No: D3165-1 PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA:  Date: 05/05/09

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3165	REV. A SHEET 1 OF 1
DATE 02.07.09		TITLE SUPPORT ARM	SCALE 1:3
A	02.07.09	NEW ISSUE	

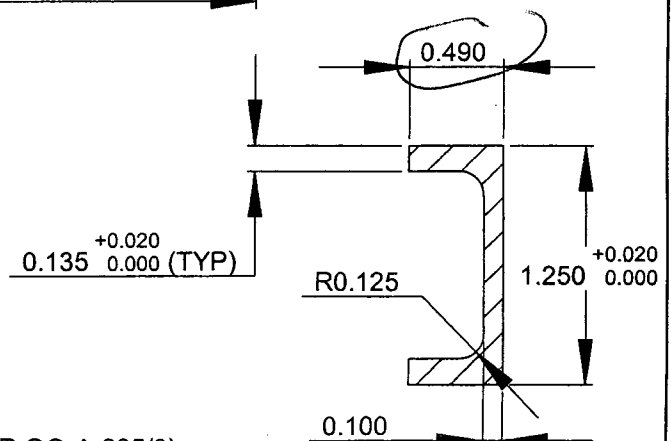
ENGRAVE P/N AND BATCH NUMBER IN THIS AREA AS
REQUIRED, USING 0.150 HIGH LETTERING WITH A
MAX DEPTH OF 0.010



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SUSCEPTIBLE TO AMENDMENT
WITHOUT NOTICE

WORK ORDER
NO. 23234

RELEASED
02.08.07



D3165-1 SUPPORT ARM

- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-250/11 OR QQ-A-225/8)
PER M6061T6B
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SECTION A-A
SCALE (1 : 1)

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

May 09, 2005
10:58 am

Work Order No : 0023234
Project Name : D3165-1
Project For : WK520
Work Order Type : Main
Main WO Number :
House Part Number : D3165-1
Description : Support Arm
Manufactured : Yes
Amount Req'd : 30
Amount Done : 0
Start Date : 05-09-05
Est Finish Date : 05-19-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Order Entry No :
OE Value : 0.00

Est Mark Up : 0.000%
Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00